



Dart Aerospace Ltd.
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RBE350A93-3312-03

Job Sheet 173861



Part No: RBE350A93-3312-03 **Job Qty:** 2 ea

Part Name: Tail Rotor Hub Bushing Replacement Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 3/8/18

Job Tracking No:

Due Date: 6/25/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3312-03 Rev G IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev B 18.03.08 DWG update Rev. G DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	6/25/18	6/25/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	2 pcs	6/25/18	6/25/18	0.00	0.20	Small Fab-9		MLL DAS
110	QC	2 pcs	6/25/18	6/25/18	0.00	0.00	QC5		38
130	Packaging	2 pcs	6/25/18	6/25/18	0.00	0.00	Packaging3-2	DAS	MLL 9-89
140	QC21-FG	2 Ea	6/25/18	6/25/18	0.00	0.00	QC21	21 9-89	JUL 05 2018

Part Op 100 - Assemble as per DWG sheet 1.
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90685A110 65	Hex Nut M12 X 1.75mm	2 Ea (1 ea)	90-Start up Operation	5036847
95327A708 38	Hex Head Screw M12 X 1.75mm x 100mm LG. (Mcmaster)	2 Ea (1 ea)	90-Start up Operation	5086846
RBE350A93-3312-03-1 Receiver 141		2 Ea (1 ea)	90-Start up Operation	1X5082114
RBE350A93-3312-03-3 Remover / Installer		2 Ea (1 ea)	90-Start up Operation	5089414
RBE350A93-3312-03-5 Seat 141		2 Ea (1 ea)	90-Start up Operation	5084028
RBE350A93-3312-03-7 Washer 141		2 Ea (1 ea)	90-Start up Operation	5084027

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90685A110	2	44	0
	95327A708	2	44	0
	RBE350A93-3312-03-1	2	13	0
	RBE350A93-3312-03-3	2	0	0
	RBE350A93-3312-03-5	2	0	0
	RBE350A93-3312-03-7	2	0	0

Part Specifications

Specifications could not be found.

Plex 7/4/18 3:03 PM dart.logan.david

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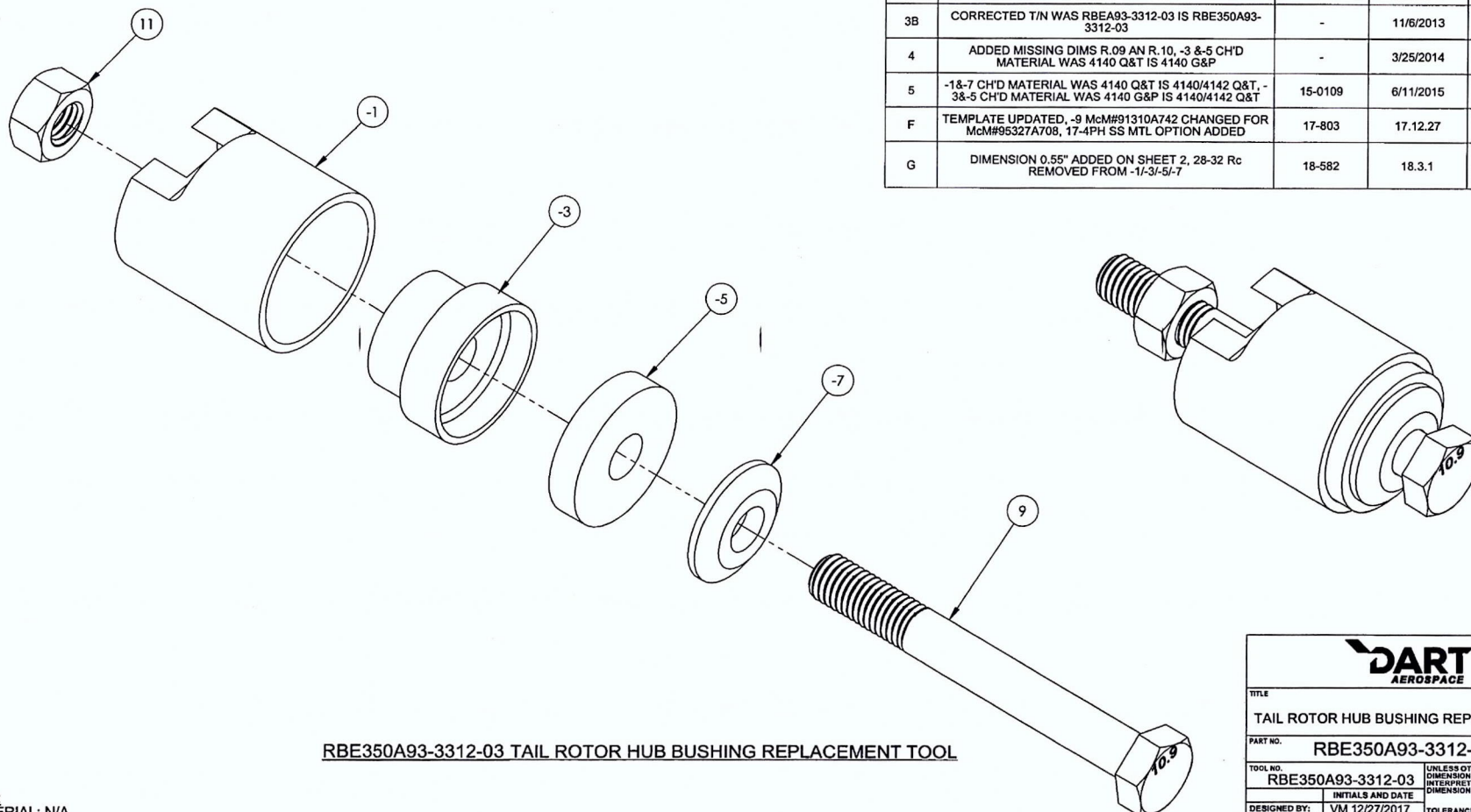
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Container No: 500013
Part: RD2350A33-3012-03
Job No: 170001
Serial No/Date: 6000100
Revision: G
Inspector:
Exp Date:
Instructions:

Date: 07/04/18

ITEM #	QTY	PART #	TITLE
-1	1	RBE350A93-3312-03-1	RECEIVER
-3	1	RBE350A93-3312-03-3	REMOVER / INSTALLER
-5	1	RBE350A93-3312-03-5	SEAT
-7	1	RBE350A93-3312-03-7	WASHER
9	1	McMaster#95327A708	HEX HEAD SCREW M12 x 1.75 x 100mm LG.
11	1	McMaster#90685A110	HEX NUT M12 x 1.75

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	-01 ADDED S/N, "MADE IN USA"	-	4/29/2009	RJC	-
2	CH'D ALL HOLES FROM 12.2mm TO 12mm FOR BETTER TOOL ALIGNMENT, CHANGES MADE TO MATCH CURRENT HELI-PRODUCTS TOOLS AND MORE OPEN TOLERANCES, -01 CH'D DEPTH FROM .984 TO 1.06, ADDED R12 FOR LOOSER TOLERANCE, -03 CH'D DIM FROM DIA 1.480 TO 1.487, FROM .939 TO .945, ADDED R.03, -05 CH'D DIM WAS DIA 1.480 IS 1.487	-	9/30/2009	WP	RW
3	-01 CH'D DIM WAS DIA 1.500 IS DIA 1.500 +/-0.003	-	12/15/2010	RJC	RW
3A	-03 ADDED MISSING DIM .325	-	9/20/2011	RJC	GE
3B	CORRECTED T/N WAS RBEA93-3312-03 IS RBE350A93-3312-03	-	11/6/2013	RJC	RW
4	ADDED MISSING DIMS R.09 AN R.10, -3 & -5 CH'D MATERIAL WAS 4140 Q&T IS 4140 G&P	-	3/25/2014	DPD	GE
5	-1& -7 CH'D MATERIAL WAS 4140 Q&T IS 4140/4142 Q&T, -3& -5 CH'D MATERIAL WAS 4140 G&P IS 4140/4142 Q&T	15-0109	6/11/2015	RJC	JAG
F	TEMPLATE UPDATED, -9 McM#91310A742 CHANGED FOR McM#95327A708, 17-4PH SS MTL OPTION ADDED	17-803	17.12.27	VM	ML
G	DIMENSION 0.55" ADDED ON SHEET 2, 28-32 Rc REMOVED FROM -1/-3/-5/-7	18-582	18.3.1	VM	ML



RBE350A93-3312-03 TAIL ROTOR HUB BUSHING REPLACEMENT TOOL

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE TAIL ROTOR HUB BUSHING REPLACEMENT TOOL	
PART NO. RBE350A93-3312-03	REV G
TOOL NO. RBE350A93-3312-03	
INITIALS AND DATE	
DESIGNED BY: VM 12/27/2017	TOLERANCES: XXX ± .005 XX ± .01 X ± .1
DRAWN BY: VM 03/01/2018	FRACTIONS ± 1/8 ANGLES ± .5° SURFACE ROUGHNESS
CHECKED BY: VM 03/01/2018	
MFG REVIEW BY: JFC 03/01/2018	
APPROVED BY: ML 03/01/2018	SCALE: NTS SHEET 1 OF 5
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